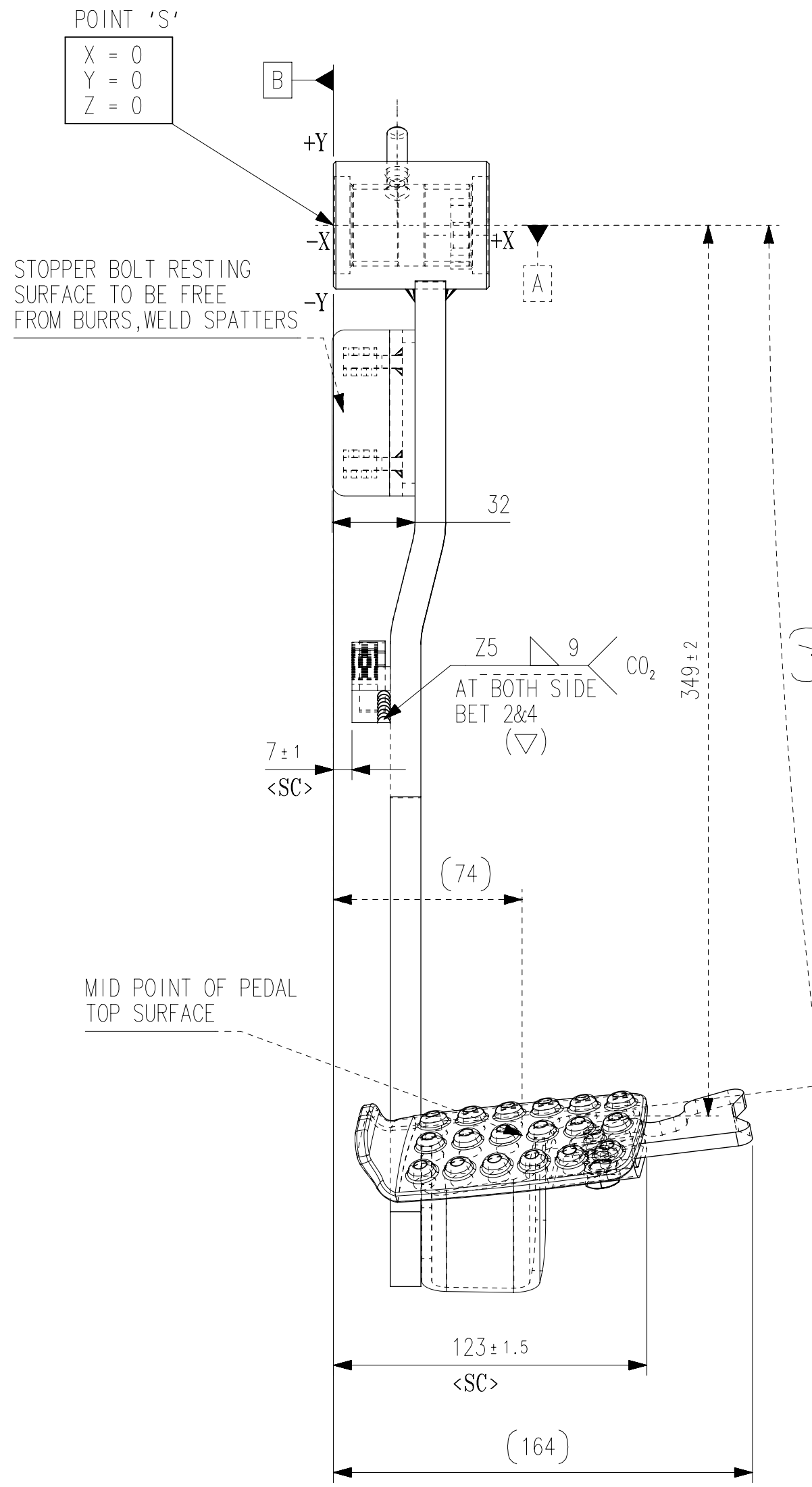
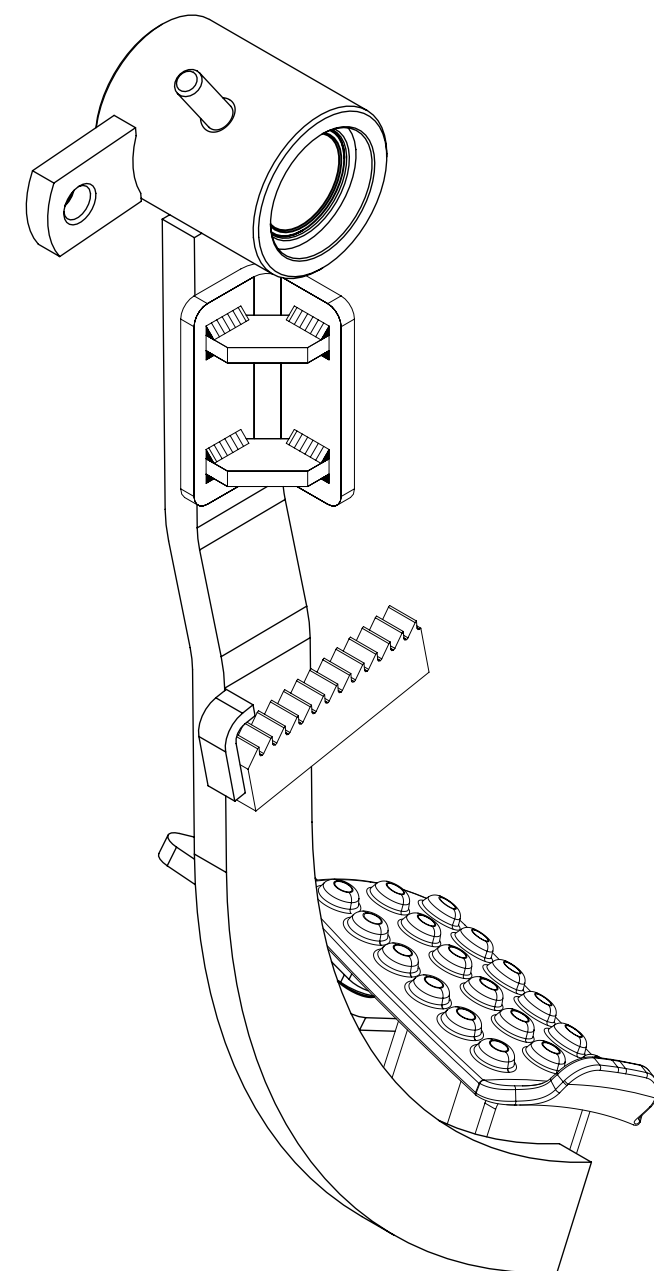


1. GENERAL TOLERANCE
UP TO 300 : ± 0.8
ABOVE 300 : ± 1.0
2. ANGULAR TOLERANCE $\pm 1^\circ$

1. FORMING TO FORMING	
< 500	± 0.5
> 500	± 0.8
2. CD BETWEEN HOLES	
IN ONE PLANE	± 0.2
IN DIFFERENT PLANES	± 0.5
3. FORM TO PIERCE	± 0.5
4. ANGULAR TOLERANCE	± 1°
5. HOLES SIZES	± 0.2/0
6. SLOT SIZES	± 0.8/0
7. GENERAL TOLERANCES	
UP TO 300	± 0.8
ABOVE 300	± 1.0
8. FLANGE WIDTH	+1.0/-0.7
9. JOGGLE DEPTH	± 0.3/0



WELDING DETAILS:-			
WELDING BETWEEN	WELD LENGTH		
	Z3	Z4	Z5
1&2	-	-	90
3&8	82	-	-
3&5	48	-	-
2&4	-	-	50
2&7	-	-	180
2&8	-	120	-
9&4	20	-	-
TOTAL WELD LENGTH = 590mm			

1. REMOVE BURRS AND SHARP EDGES.
2. CO₂ WELDING TO BE CARRIED OUT AS PER PS 608.
3. DO NOT PRIME HOLE ID AND SHAFT SURFACES.
4. UNPRIMED SURFACES SHOULD BE COATED WITH RUST PREVENTIVE OIL.
5. 3D GENERATED CAD DATA IS MASTER FOR THE PART.
6. PART ACCEPTANCE CRITERIA:- ACCEPTANCE OF THE PART USING QUALIFYING GAUGE

PROCUREMENT CONDITION:-	
PART NO	SUPPLY CONDITION
0P7540852C91	PRIMING AS PER T04 308-0230

SL.NO	PART NO.	DESCRIPTION	QTY	MATERIAL	WT (Kg)
1.	007540848C91	BRAKE PIVOT LH ASSY	1	---	0.573
2.	007541095C1	BRAKE PEDAL LH	1	Fe 410WB:IS 2062	1.278
3.	007540763C1	FOOT PEDAL	1	Fe 410WB:IS 2062	0.269
4.	007541185C1	RATCHET HAND BRAKE	1	C45/EN8:IS-1570	0.112
5.	007541178C91	PEDAL LOCK ASSY	1	----	0.163
6.	007542056C1	PEDAL BUSH M-STAR	2	SINTERED PHOSPHOR BRONZE IS:3980:1982	0.06
7.	007541916C91	BKT ASSY BRAKE PEDAL STOPPER	1	Fe 410WB:IS 2062	0.173
8.	007541310C1	SUPPORT GUSSET	1	Fe 410WB:IS 2062	0.160
9.	007609914C1	RACHET STOPPER PLATE	1	Fe 410WB:IS 2062	0.01

<SC> :SIGNIFICANT CHARACTERISTICS ▽:CRITICAL CHARACTERISTICS

BREAK SHARP CORNERS MAY BE EITHER A CHAMFER OR A RADIUS FROM 0.2 mm MIN. TO 1.0 mm MAX.										MAHINDRA & MAHINDRA LIMITED TRACTOR DIVISION KANDIVLI(EAST), MUMBAI 400 101, INDIA.									
UNSPECIFIED TOLERANCES AS PER ISO-2768-1-1989										E.R./PROC.REQ.NO. : PART NAME : ER14C0002710									
DIMENSIONS										PART NO. : 007540852C91									
LINEAR IN mm										OVER									
UPTO										0.5 3 6 30 120 400 1000 2000									
FINE										0.250 ± 0.08 ± 0.10 ± 0.12 ± 0.15 ± 0.20 ± 0.25 ± 0.30 ± 0.40									
MEDIUM										(0.30) ± 0.11 ± 0.14 ± 0.16 ± 0.20 ± 0.25 ± 0.30 ± 0.35 ± 0.45									
COARSE										(0.40) ± 0.12 ± 0.15 ± 0.18 ± 0.22 ± 0.28 ± 0.35 ± 0.40 ± 0.50									
VERY COARSE										(X) ± 0.20 ± 0.25 ± 0.30 ± 0.38 ± 0.48 ± 0.58 ± 0.68 ± 0.80									
ANGULAR IN deg.										LENGTH OF SHORTEST SIDE OF THE ANGLE IN mm.									
UPTO										10 50 120 400 400									
FINE										(0.005) ± 1° ± 0° 30' ± 0° 20' ± 0° 15' ± 0° 10' ± 0° 5'									
MEDIUM										(0.01) ± 1° ± 0° 30' ± 0° 20' ± 0° 15' ± 0° 10' ± 0° 5'									
COARSE										(0.01) ± 1° ± 0° 30' ± 0° 20' ± 0° 15' ± 0° 10' ± 0° 5'									
VERY COARSE										(X) ± 1° ± 2° ± 1° ± 0° 50' ± 0° 25'									
PART OF THIS DRAWING / DOCUMENT SHOULD NOT BE REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF M & M LTD.																			
COMPUTER GENERATED DRAWING										DO NOT CHANGE MANUALLY									
IF IN DOUBT ASK										DO NOT SCALE									
DRG SIZE : A1										ALL DIMENSIONS ARE IN mm.									
CHECKED BY: LATEST CHANGE No										CHECKED BY: LATEST CHANGE No									